



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3303-02-3

Job Sheet 170596



Part No: RBE350A93-3303-02-3

Job Qty: 6 ea

Part Name: Extractor



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBE350A93-3303-02 REV 4 IPP REV A 18-01-17 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/27/18	0.00	0.00	Start Up Waterjet2		OK 18/02/08
100	Waterjet	6 pcs		2/27/18	0.25	0.75	Waterjet 2 OMAX		OK 18/02/08
110	QC	6 pcs		2/27/18	0.00	0.00	QC2 Waterjet-4		OK 18/02/08
120	Mori Seiki	6 pcs		2/27/18	1.00	1.50	MORI NV5000-1		OK 18/02/19
130	QC	6 pcs		2/27/18	0.00	0.00	QC2 Machining-5		OK 18/02/19
140	QC	6 pcs		2/27/18	0.00	0.00	QC8 Machining-5		OK 18-02-26
170	Outsource	6 pcs		2/27/18	0.00	0.00	Outsource12		AT 18/03/19
180	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging2		AT 18/03/19
190	QC	6 pcs		2/27/18	0.00	0.00	QC6		OK 38
200	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging3-2		OK 38
210	QC21-SA	6 Ea		2/27/18	0.00	0.00	QC21		OK 38

Part Op 100 - 1-Cut as per Dwg Dwg Rev: 4 Prog Rev: 4 2-Deburr if necessary
Descriptions: 120 - 1-Machine as per folio FB740 FOLIO REV: 4 DWG REV: 4 2-Deburr
170 - Issue P/O to Groupe Altech; PO 039186 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required
180 - Receive
200 - IDENTIFY AND STOCK

OKB MAR 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018B1.000X03.000	1010-1025 Steel Bar 1.000 X 3.000	1.9380 ft (.323 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/17/18 11:32 AM Dart.lajeunesse.marie

OKB 3-21

DART
AEROSPACE
S040695

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Extractor

PART NO: RBE350A93 - 3303 - 02 - 3

Original Serial #: S040695

Revision:

Operation:

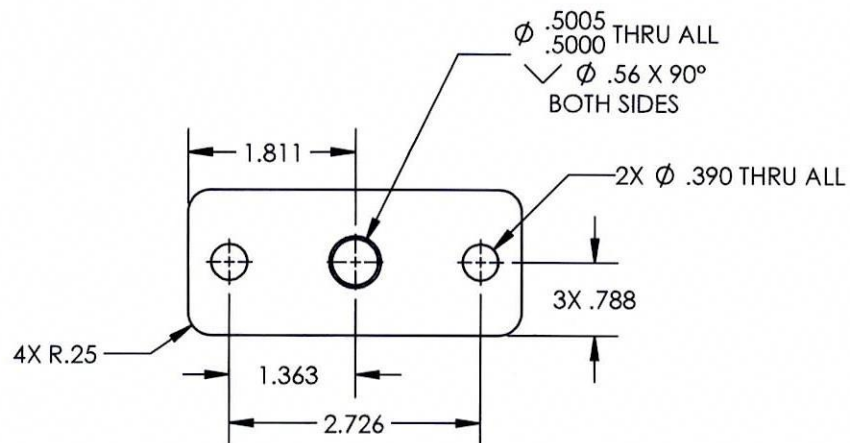
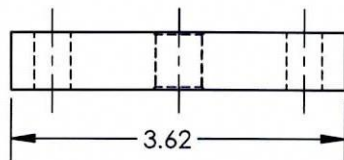
Change No:

Start up Operation 02/08/18

Job No: 170596

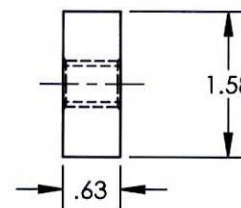
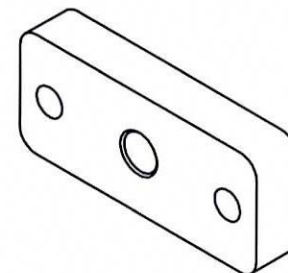
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-3 CH'D HOLES FROM Ø.413 AND ADDED R.25 TO CORNERS.	12/4/2008	WP	DW
3		-3 CH'D DIMS WAS Ø.500 IS LIMITS Ø.5000 - .5005, WAS .630 IS (.625).	3/13/2014	DPD	GE
4	15-0132	-3 CH'D MATERIAL WAS 1018 IS A36/1018/1020.	6/10/2015	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 170596 u15
18-01-17



(-3)
EXTRACTOR

DART AEROSPACE	
TITLE T/R BODY EXTRACTOR TOOL	
DWG NO. RBE350A93-3303-02-3	REV 4
MAT'L A36/1018/1020	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± .5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	EUROCOPTER AS350A
SCALE 1:2	DATE 10/27/2008
SHEET 3 OF 5	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039186

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039186

PO Date: 3/2/18

Due Date: 3/16/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

E-MAILED
MAR 07 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170482	646.3913	Shim Issue P/O: _____ Cad Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	3/16/18	35 pcs	0 pcs	35 pcs	\$5.00/pcs	\$175.00
2	170332	RBE2-10-1-01	Slide -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	3/16/18	6 pcs	0 pcs	6 pcs	\$1.95/pcs	\$11.70
3	170569	RBE350A93-3303-02-1	Receiver Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/16/18	6 pcs	0 pcs	6 pcs	\$5.41/pcs	\$32.46
4	170596	RBE350A93-3303-02-3	Extractor Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/16/18	6 pcs	0 pcs	6 pcs	\$2.05/pcs	\$12.30
5	171364	RBE350A93-3317-20	Tail Rotor Hub Insert Tool Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/16/18	6 pcs	0 pcs	6 pcs	\$5.41/pcs	\$32.46



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007318- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
16-Mar-2018		Celine Schreindorfer			P0039186			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	RBE2-10-1-01 Rev.	RBE2-10-1-01 01 -BLACK OXIDE ON SST MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4	BLACK-OXIDE CH	6	6	0	0	0
3	RBE350A93-3303-02-1 Rev.	RBE350A93-3303-02-1 01 -BLACK OXIDE FINISH M MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
4	RBE350A93-3303-02-3 Rev.	RBE350A93-3303-02-3 01 -BLACK OXIDE FINISH ON SST MIL-C-13942C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
5	RBE350A93-3317-20 Rev.	RBE350A93-3317-20 01 -BLACK OXIDE FINISH ON SST MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
6	RB412WA-CR&O-3-62-2A-1-2 Rev.	RB412WA-CR&O-3-62-2A-1-2 ASTM B633 TYPE 1 SC2 01 - ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT]	ZINC CH	✓ 4	4	0	0	0
7	RBW6405G02331-3G-05 Rev.	RBW6405G02331-3G-05 ON SST MIL-C-13924C, CLASS 1 01 - ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT]	ZINC CH	✓ 2	2	0	0	0
8	RBW6405G02331-3G-07 Rev.	RBW6405G02331-3G-07 ASTM B633 TYPE 1 SC2 01 - ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT]	ZINC CH	✓ 9	9	0	0	0
10	RBST1007-13 Rev.	RBST1007-13 01 -BLACK OXIDE ON SST MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
11	RBT18603-01 Rev.	RBT18603-01 01 -BLACK OXIDE ON SST MIL-DTL-13924C CLASS 1	BLACK-OXIDE CH	5	5	0	0	0
12	RBT18603-07 Rev.	RBT18603-07 01 -BLACK OXIDE ON SST MIL-DTL-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
13	RBST1007-11 Rev.	RBST1007-11 01 -BLACK OXIDE ON SST MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
9. RBE350A94-3700-C-4				9	9			

Certificat de Conformité / Certificate of Compliance



Bon de Livraison / Packing Slip

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DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Notes Additionnelles / Additional Notes

Reçu par
Received By

Page 2 of 2